

# Work Order ID 74509

Monday, October 03, 2011 2:36:36 PM



Page 1

Item ID: D3535-35

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 9/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan: M.L. J

Date: 11/10/03 Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3535

Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3535

☐ Dwg Rev: B

☐ Prog Rev: B

☐ 2-

Deburr if necessary

B11-10-28

B11-10-27



110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B11-10-27

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

B11-10-28



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 74509**

Monday, October 03, 2011 2:36:36 PM



Page 2

Item ID: D3535-35

Accept



Setup Start



Revision ID:

Stop



Item Name: Wearshoe

Start Date: 9/30/2011 Start Qty: 12.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130



NC BRAKE

0.00

Brake NC

Memo

0.00

Brake NC

1-Deburr if necessary ☐ 2-Form on Brake as per Dwg D3535 using Jigs  
DT8261 and DT8326. ☐ 3-Identify as D3535-35.

JB 11/10/30

(12)

140



QC5- Inspect part completeness to step on W/O

0.00

QC

Memo

0.00

Quality Control

M 11 10 31 (12)

150



Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Powdercoat

Memo

0.00

Powder Coating

START TIME: 3:45 ☐ OVEN TEMPERATURE:  
☐ FINISH TIME: 4:15

12x4 M 11/11/01

M118439

3200 F

4:15

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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**NOTE:** Date & initial all entries

# Picklist Print

Page 1

Monday, October 03, 2011 2:36:42 PM

Work Order ID: 74509



Parent Item: D3535-35



Parent Item Name: Wearshoe

Start Date: 9/30/2011

Required Date: 10/14/2011

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A New Issue 07-02-15 JLM  
IPP Rev:B As per Rev B 07-08-31 JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S20GA

Purchased

No

100

sf

170.5795

0.8022

10.13305



B1170-07

304/316 .040 Sheet

Location

Loc Qty

Loc Code

MAT020

170.5795

116623

0.2

117550

8.363

117933

45.3442

118400

33.6723

118964

83

~~119336~~

119346

~~119336~~

119346

(12)

W/O:		WORK ORDER CHANGES					
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**NOTE:** Date & initial all entries

<b>DART AEROSPACE LTD</b>		<b>Work Order:</b> 74509
<b>Description:</b> Wearshoe		<b>Part Number:</b> D3535-35
<b>Inspection Dwg:</b> D3535	<b>Rev:</b> B	<b>Page 1 of 1</b>

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.000	+/-0.010	2.000	✓		V BoZ	
1.885	+/-0.010	1.884	✓		V	
6.00	+/-0.030	6.00	✓		T Bo1	
6.75	+/-0.030	6.75	✓		T	
Ø0.188	+0.005/-0.001	.193	✓		V	
23.250	+/-0.010	23.250	✓		T	
19.750	+/-0.010	19.750	✓		T	
17.750	+/-0.010	17.750	✓		T	
14.250	+/-0.010	14.250	✓		T	
9.500	+/-0.010	9.500	✓		T	
4.750	+/-0.010	4.750	✓		T	
0.300	+/-0.010	.303	✓		V	
0.300	+/-0.010	.307	✓		V	
0.038	+/-0.010	.035	✓		V	

<b>Measured by:</b> IB	<b>Audited by:</b> S	<b>Prototype Approval:</b>	N/A
<b>Date:</b> 11-10-27	<b>Date:</b> 11/10/28	<b>Date:</b>	N/A

Rev	Date	Change	Revised by	Approved
A	07.05.10	New Issue	KJ/JLM	BE

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

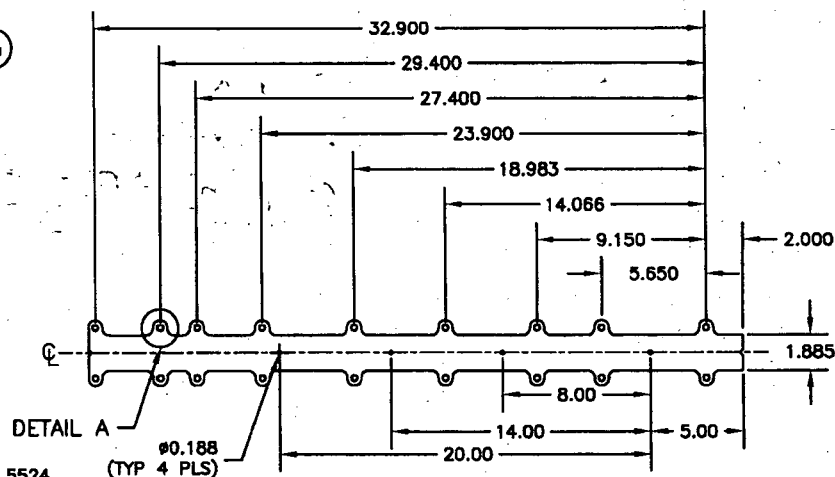
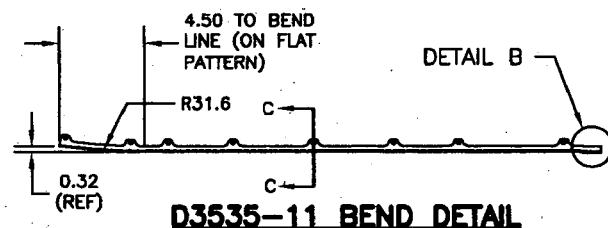
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

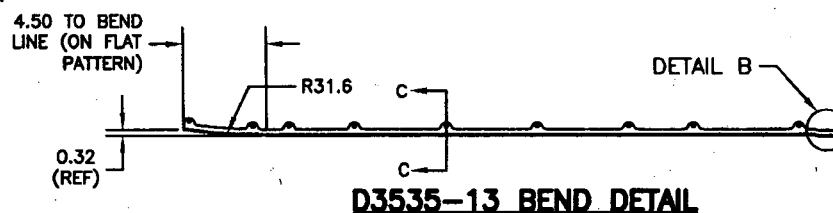
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CB	PH	PORT HADLOCK, WA	
CHECKED	APPROVED	DRAWING NO.	REV. B
<del>TH</del>	<del>TH</del>	D3535	SHEET 1 OF 7
DATE	TITLE		SCALE
07.04.17	WEARSHOE		1:10
A	06.10.25	NEW ISSUE	
B	07.04.17	MOVE TAB OUTBOARD, ADD AMS SPEC	

57.04.24

5 M.L.J  
11/10/03



**D3535-13F FLAT PATTERN**



- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524,  
20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER  
QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS  
OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT  
PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION
- 4.50 TO BEND  
LINE (ON FLAT  
PATTERN)
- 0.32  
(REF)

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

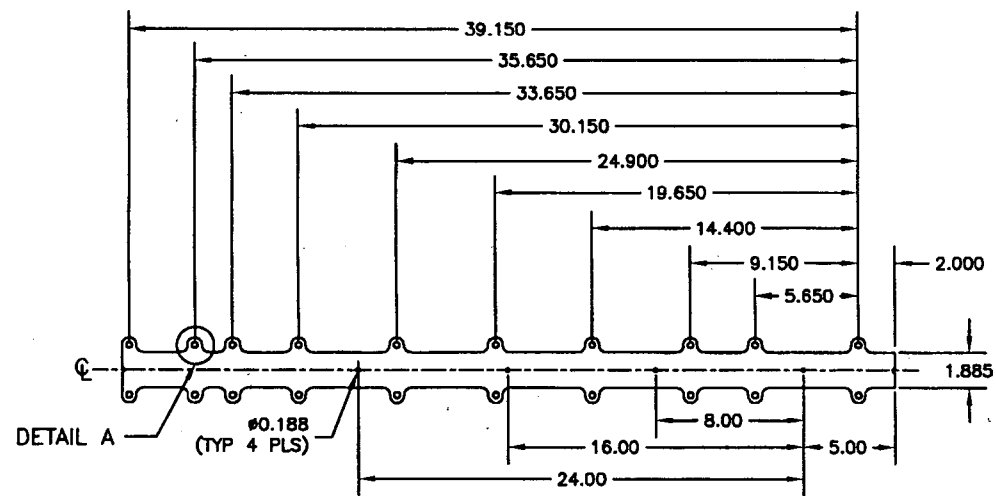
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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**NOTE:** Date & initial all entries

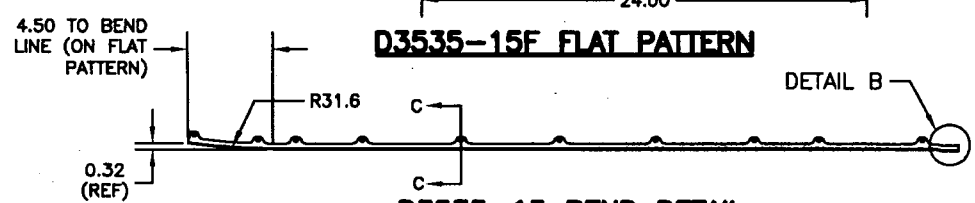
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07.04.24 #

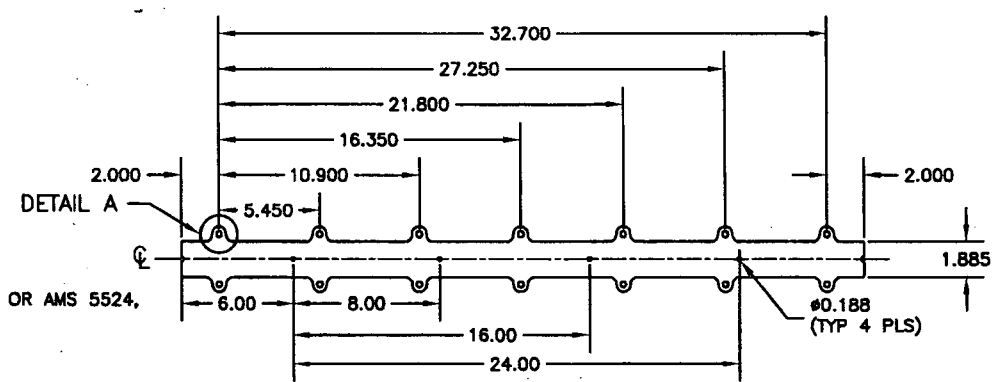
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CHECKED	#	APPROVED	#	PORT HADLOCK, WA	
DATE	07.04.17	DRAWING NO.	D3535	TITLE	WEARSHOE
				SCALE	1:10
				SHEET	2 OF 7



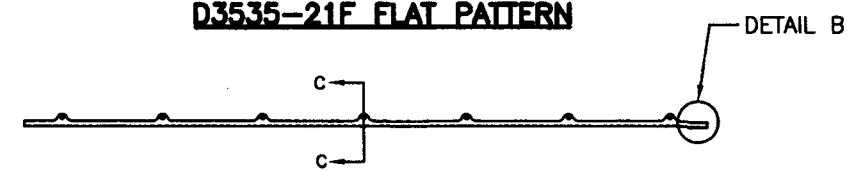
**D3535-15F FLAT PATTERN**



**D3535-15 BEND DETAIL**



**D3535-21F FLAT PATTERN**



**D3535-21 BEND DETAIL**

**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT C
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES TO 0.010 MAX
- 7) IDENTIFY WITH DART P/N USING WHITE FINE POINT PAINT MARKER
- 8) SEE PAGE 7 FOR DETAILS AND SECTION

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74509

W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

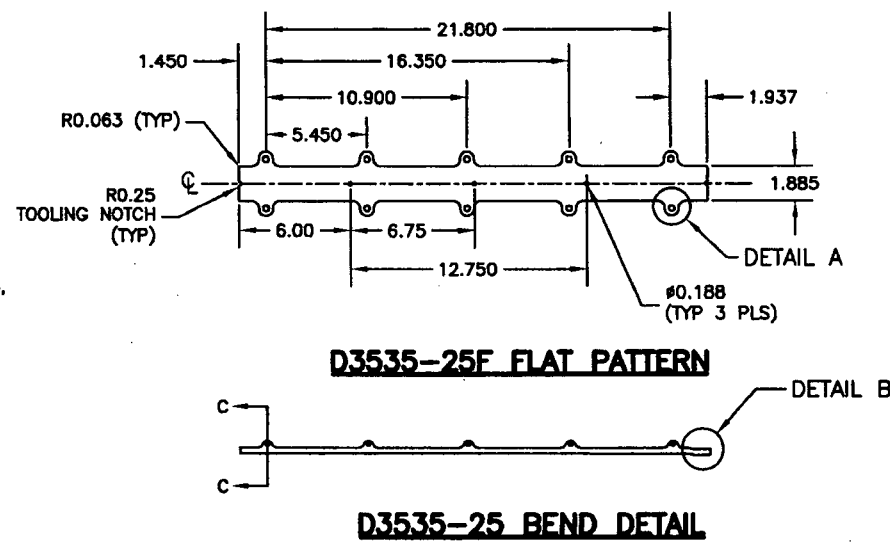
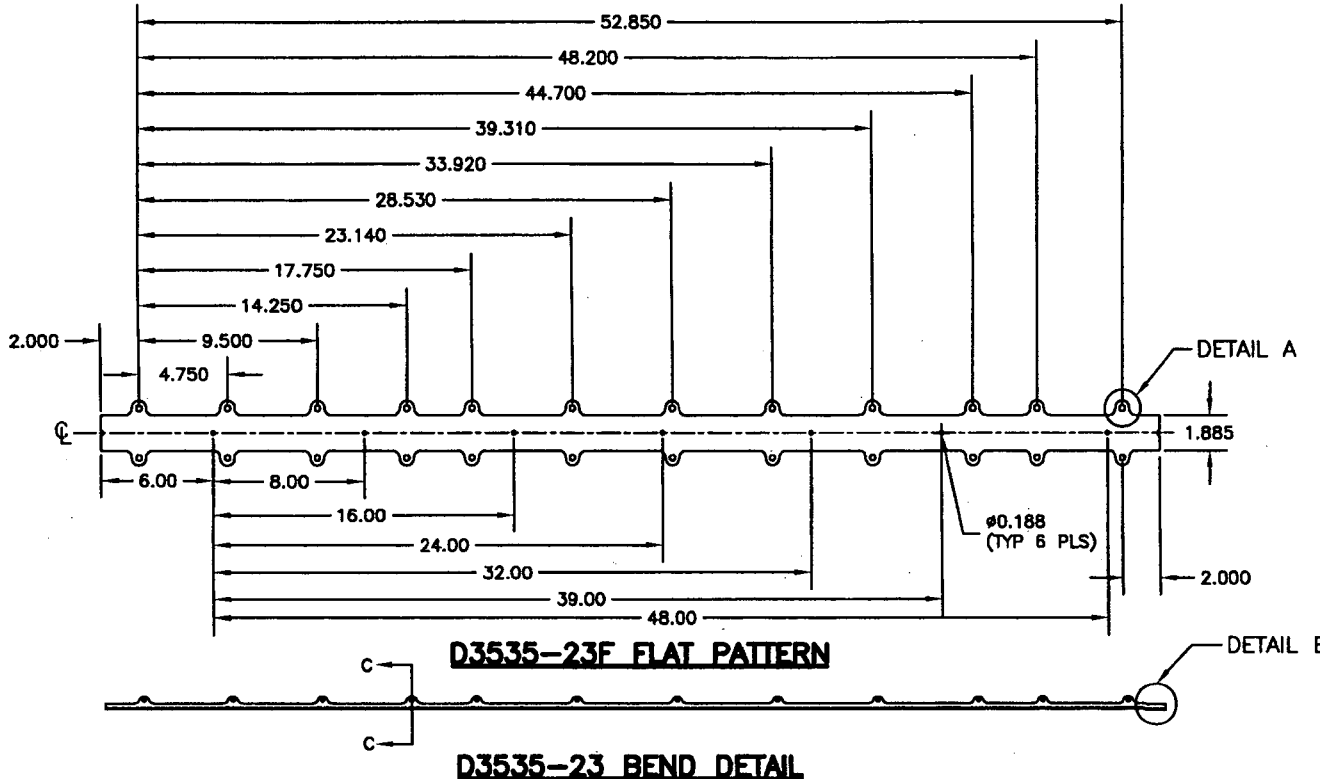
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

74509

**DART**

RELEASED  
07 04 24



- NOTES**
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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  - 8) SEE PAGE 7 FOR DETAILS AND SECTION

DESIGN	CB	DRAWN BY	PH	DART AEROSPACE USA, INC.
CHECKED	PH	APPROVED	PH	PORT HADLOCK, WA
DATE	07.04.17	TITLE	WEARSHOE	REV. B
				SHEET 3 OF 7
				SCALE 1:10

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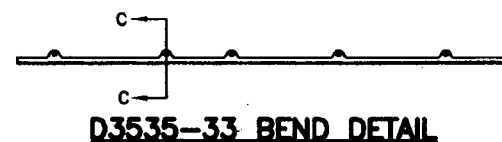
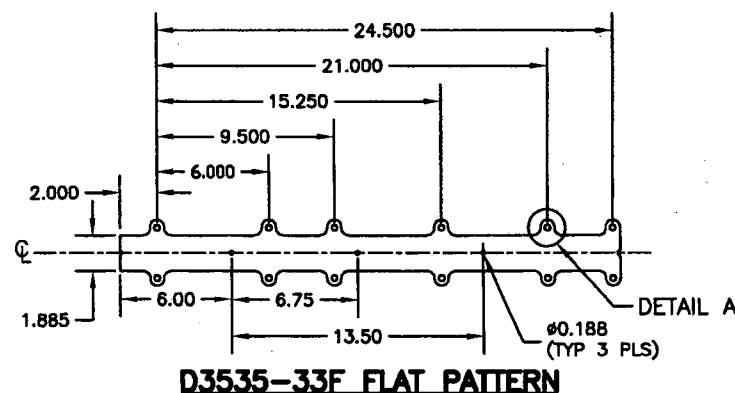
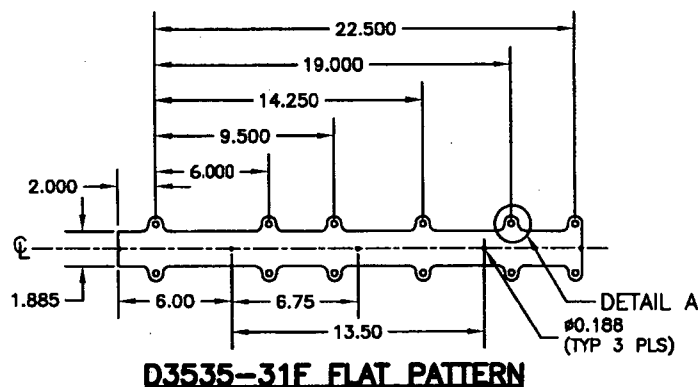
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**DART**

RELEASED  
07.04.17

DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA	REV. B
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3535</b>	SHEET 4 OF 7
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	SCALE <b>1:10</b>	



**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)  
(REF DART SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 3) PART IS SYMMETRICAL ABOUT  $\phi$
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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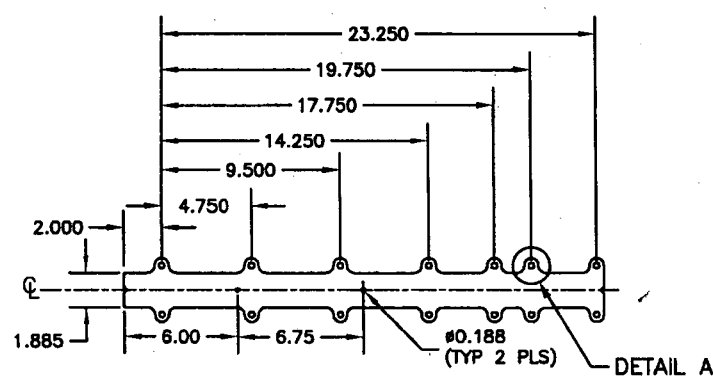
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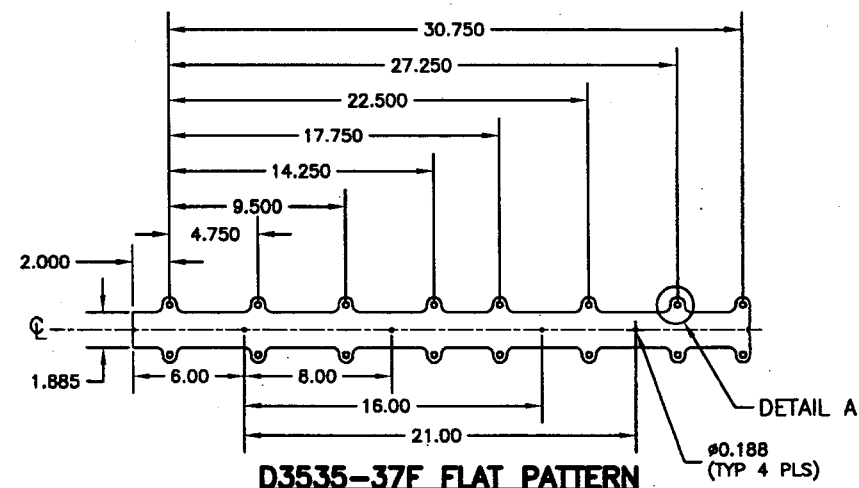
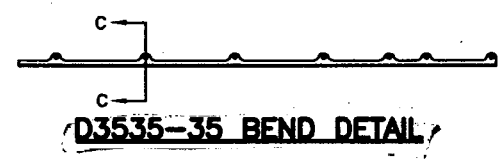
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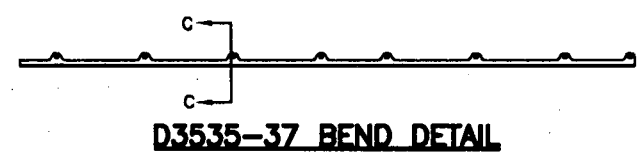
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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. <b>D3535</b>	SHEET 5 OF 7
DATE <b>07.04.17</b>	TITLE <b>WEARSHOE</b>	SCALE <b>1:10</b>	



**D3535-35F FLAT PATTERN**



**D3535-37F FLAT PATTERN**



**NOTES**

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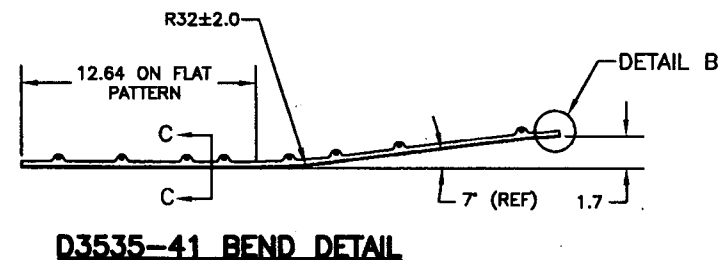
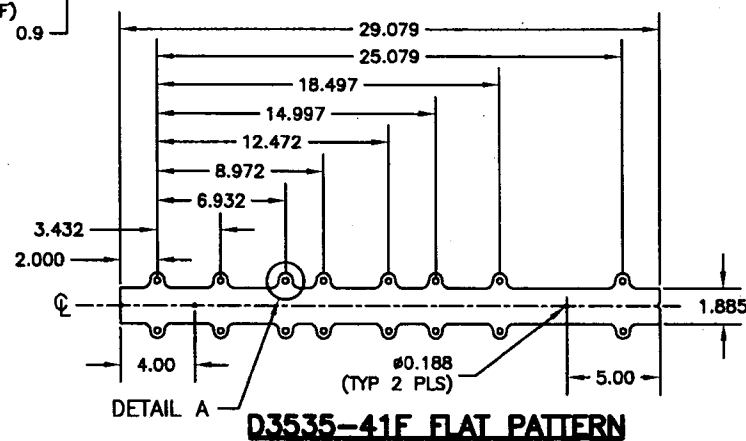
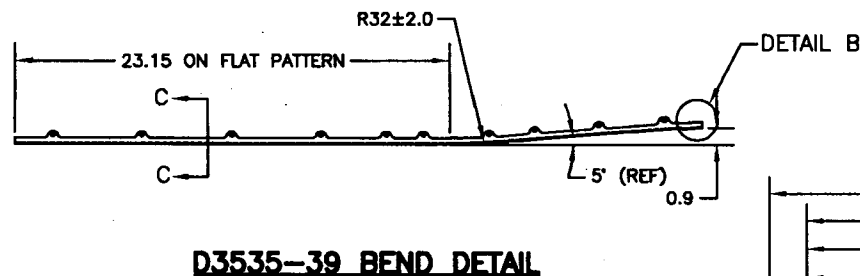
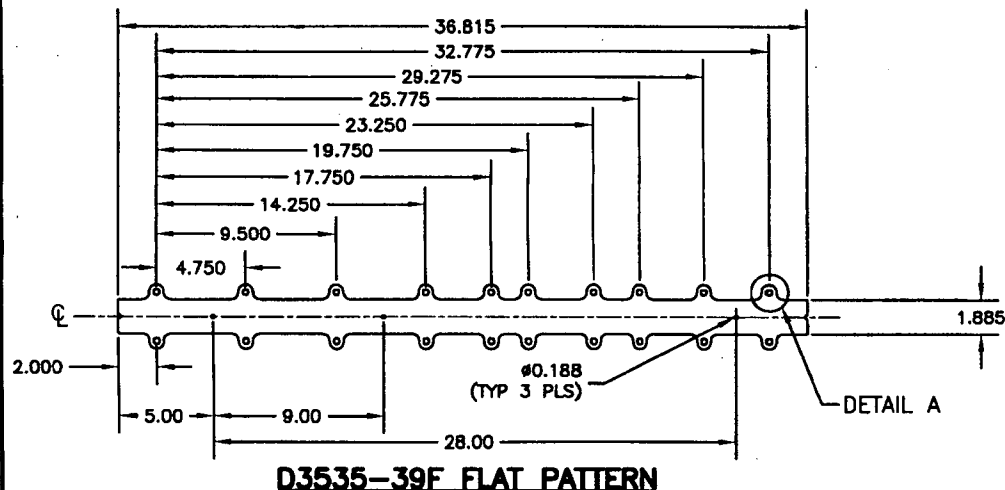
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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

74509

**DART**RELEASED  
07.04.24**NOTES**

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK) (REF DART SPEC M304S20GA)
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CHECKED	<i>[Signature]</i>	APPROVED	<i>[Signature]</i>	PORT HADLOCK, WA
DATE	07.04.17	DRAWING NO.	D3535	REV. B
TITLE	WEARSHOE	SHEET	6 OF 7	SCALE
				1:10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

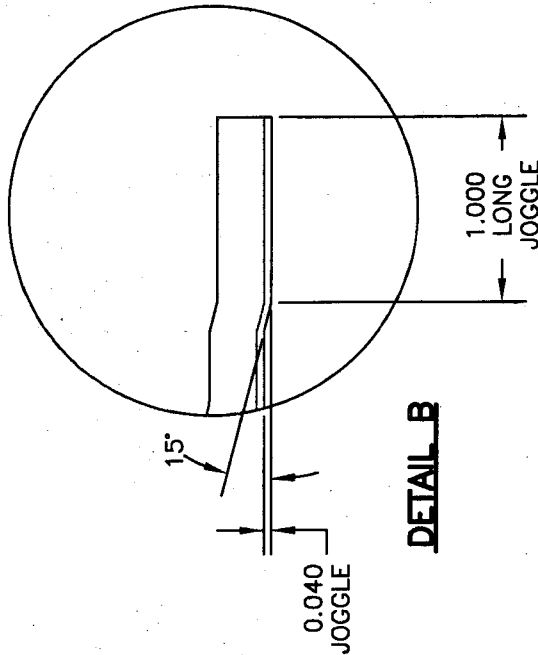
**NOTE:** Date & initial all entries



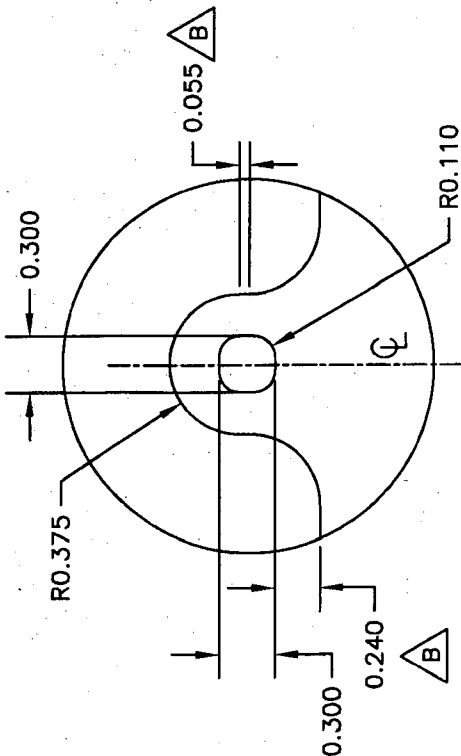
DESIGN <b>CB</b>	DRAWN BY <b>PH</b>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3535	REV. B SHEET 7 OF 7
DATE 07.04.17		TITLE WEARSHOE	SCALE 1:1

RELEASED

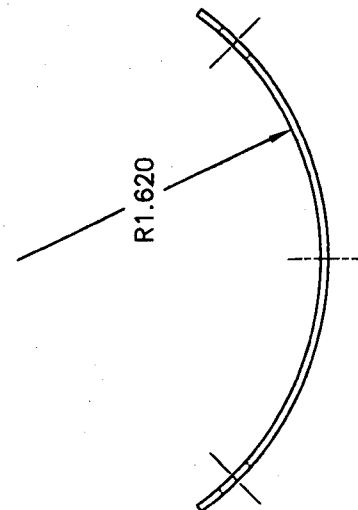
07.04.24 *[Signature]*



**DETAIL B**



**DETAIL A**



**SECTION C-C**

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries